

Date: Monday, 12/05/2008 9:58:09 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 STEP END PLATE
Job Number	: 39179		
Estimate Number	: 11021		
P.O. Number	:	Part Number	: D2734
This Issue	: 12/05/2008 S.O. No. :	Drawing Number	: D2734 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 36520	Material	:
Written By	:	Due Date	: 25/05/2008 Qty: 200 Um: Each
Checked & Approved By	: <u>JLD 08-5-12</u>		
Comment	: Est:D 01.06.08 Removed Debur EC Est Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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14



Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s)

 Material: 5052-H32 (QQ-A-250/8) 0.063" thick
 (M5052H32S.063)
Batch: 107276 B 8-5-1319059 X30 = 2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D 2734

Dwg Rev: CProg Rev: C

B 8-5-B

(211)

2-Debur if necessary

08/05/20 (211) JLD

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-5-13



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Q2P08



Comment: SECOND CHECK

08/05/20

counters

(211)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per drawing D2734

08/05/20

(211)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/05/2008 9:58:09 AM
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Drawing Name: 206 STEP END PLATE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/05/26

counters
(121)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT RUMS

8 8/5/26

(211)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion



MF 08-05-26

Dart Aerospace Ltd

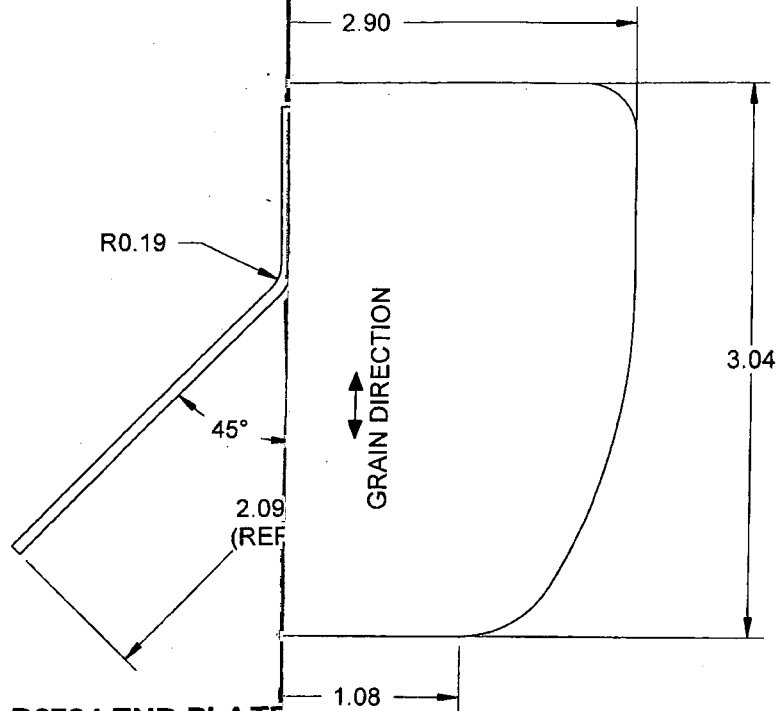
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2734 END PLATE

FLAT PATTERN

RELEASED
07.12.18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39179

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS
(REF. DART SPEC. M5052H32)
6061-T6 (OR 6061-T6) ALUMINUM
PER AMS-QQ-A-250/11 OR AMS
(REF. DART SPEC. M6061T6S)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MIN
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

TION NOTE; REDRAWN IN		DC	07.11.20
097 WAS 2.137		KE	98.10.05
		KE	97.12.10
DESCRIPTION		BY	DATE
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. C	
D2734		SHEET 1 OF 1	
TITLE		SCALE	
END PLATE		1:1	
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